

Work Order ID 68616

Monday, April 18, 2011 3:25:50 PM



Page 1

Item ID: D3016-041

Accept



Setup Start



Revision ID:

Item Name: Seat Frame Assembly

Stop



Start Date: 4/18/2011 Start Qty: 1.00

Required Date: 4/28/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-18 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3016

RevA / DEO A-1

100

Weld per dwg A/R 4130 rod Batch: 11102226 0.00



Large Fab

Memo

0.00

Large Fab

1-Cut all tubes as per Dwg D3016

2-Deburr

3-Assemble tubes, fittings and weld as per Dwg D3016 using welding jig DT8597

4-Transfer drill holes from D3017-041 and D3021-041 in seat frame D3016-041

5- Assemble brackets and gusset per dwg and weld

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-9-28 (X) 11-9-28

1 0 2E 11/05/05

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Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8 Mustos

(X) Set

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Install paint screws on fitting ends

START TIME: 11:30

OVEN TEMPERATURE: 320 OF

FINISH TIME: 12:00

(X) & m-l 11/05/06

Powder Coating

M115128

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

SAD 11-05-06

(1)

Quality Control

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Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

CA

0.00



Packaging

Memo

w/o

68752

0.00

Packaging

E/S 4/05/10

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 J

UW0510

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Page 1

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 4/18/2011

Required Date: 4/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC IPP RevB: as per revB DD verified by:JLM

[illegible]

Picklist Print

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Page 2

Work Order ID: 68616

Parent Item: D3016-041

Parent Item Name: Seat Frame Assembly

Start Date: 4/18/2011

Required Date: 4/28/2011

Start Qty: 1.00

Required Qty: 1.00

D3016-13



Bracket

Manufactured No

100 Each

14.0000

2

2



EL 11-4-28

Location

Loc Qty

Loc Code

WA019

14

44778

14

D3016-15



Gusset

Manufactured No

100 Each

5.0000

2

2



EL 11-4-28

Location

Loc Qty

Loc Code

WA019

5

43413

5

68735 x 3

D3020-1



Fitting

Manufactured No

100 Each

33.0000

4

4



EL 11-4-28

Location

Loc Qty

Loc Code

WA

33

36713

33

4

Monday, April 18, 2011 3:25:45 PM

Shop Packet Print

Page 2

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3016	REV. A SHEET 1 OF 3
DATE 01.05.18		TITLE SEAT FRAME ASSEMBLY	SCALE NTS
A	01.05.18	NEW ISSUE	

QTY	PART NUMBER	DESCRIPTION	MATERIAL
X	D3016-041	SEAT FRAME ASSEMBLY	N/A
1	D3016-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3016-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3016-5	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
2	D3016-7	TUBE	AISI 4130N TUBE, Ø0.50 DIA x 0.049 WALL (M4130N-T0500W049)
1	D3016-9	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-11	SADDLE	AISI 4130N TUBE, Ø1.00 DIA x 0.120 WALL (M4130N-T1000W120)
1	D3016-13	BRACKET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-15	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
1	D3016-17	GUSSET	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3020-1	FITTING	N/A

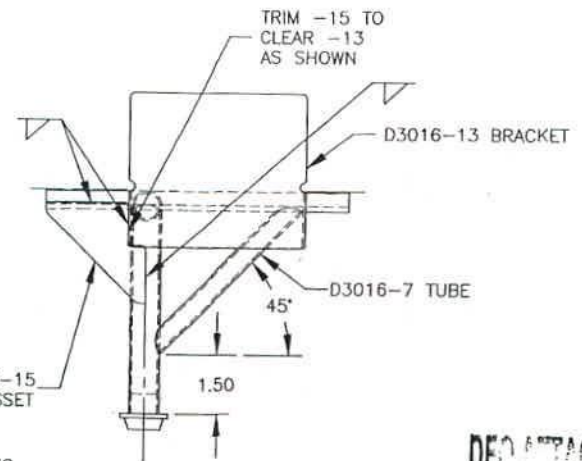
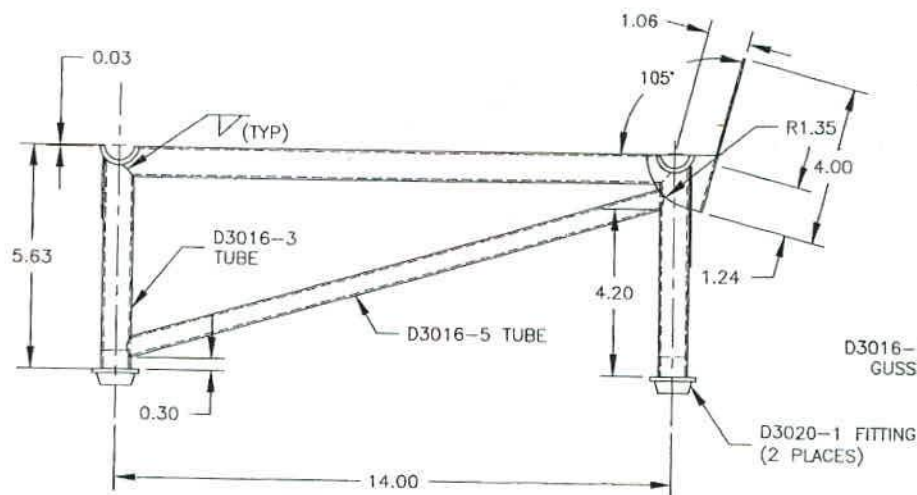
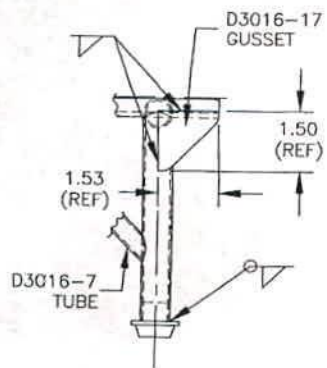
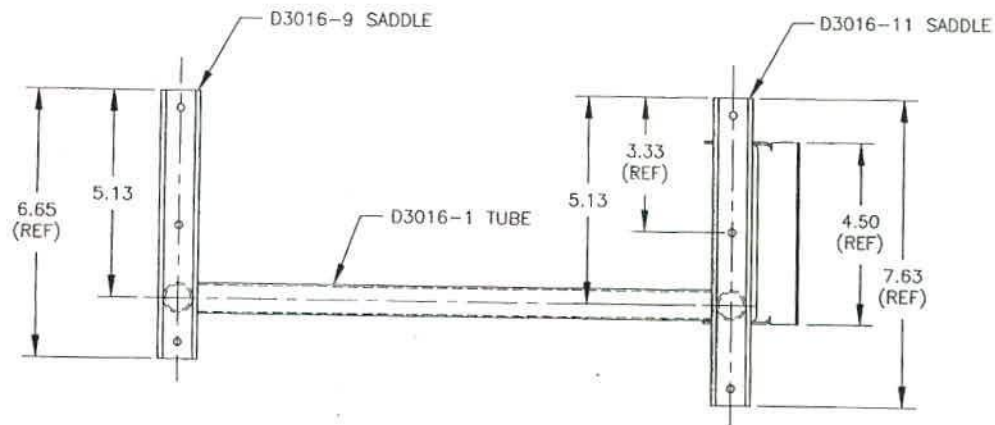
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DEO ATTACHED**RELEASED**
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D3016-041 SEAT FRAME ASSEMBLY



DETACHED
RELEASED
01.05.18

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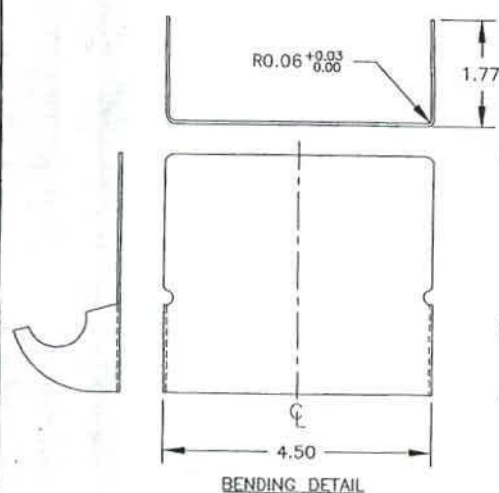
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CHECKED *[Signature]*
DATE 01.05.18

DRAWN BY *CP*
APPROVED *[Signature]*
DRAWING NO. D3016
TITLE SEAT FRAME ASSEMBLY

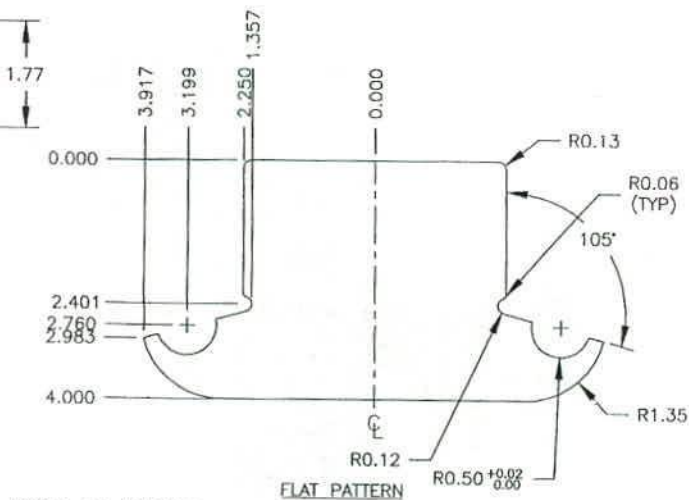
DART DART AEROSPACE LTD.
WARRICKBURGH, ONTARIO, CANADA

REV. A
SHEET 2 OF 3
SCALE 1:3

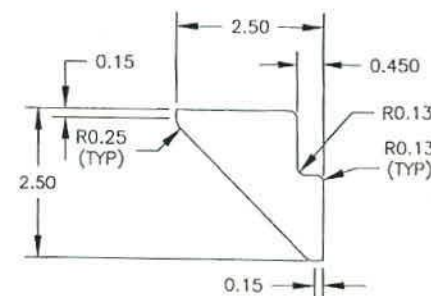
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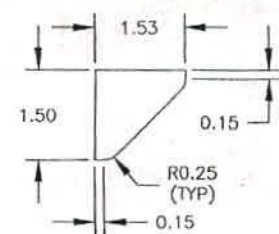
BENDING DETAIL



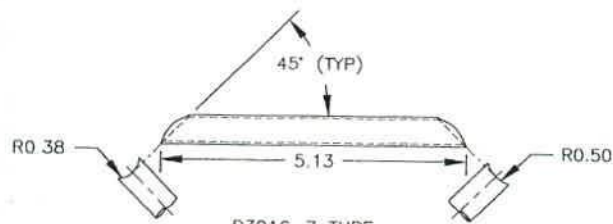
D3016-13 BRACKET



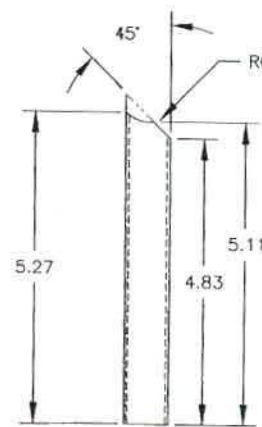
D3016-15 GUSSET



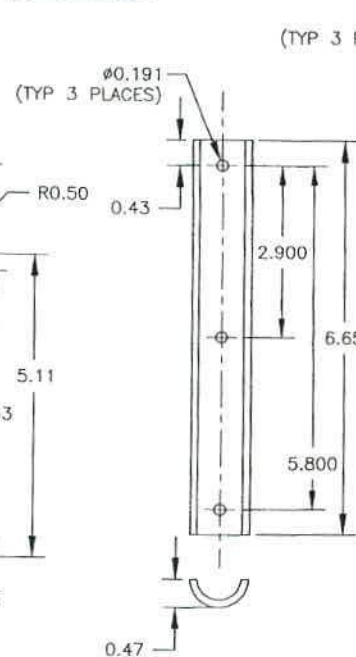
D3016-17 GUSSET



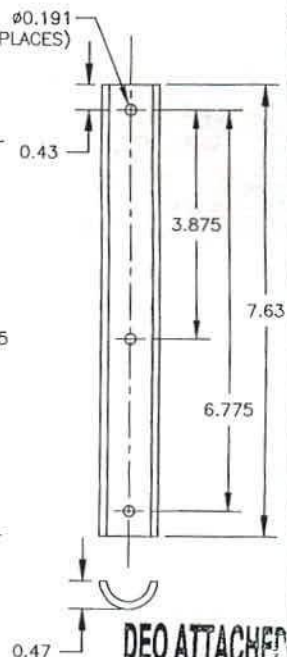
D3016-7 TUBE



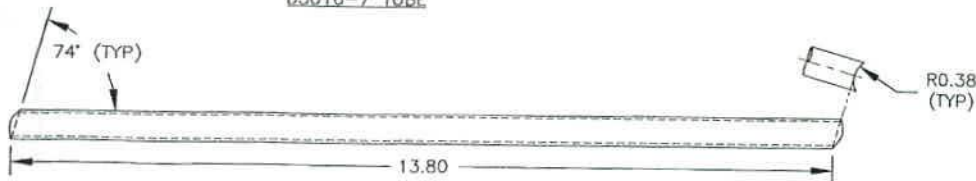
D3016-3 TUBE



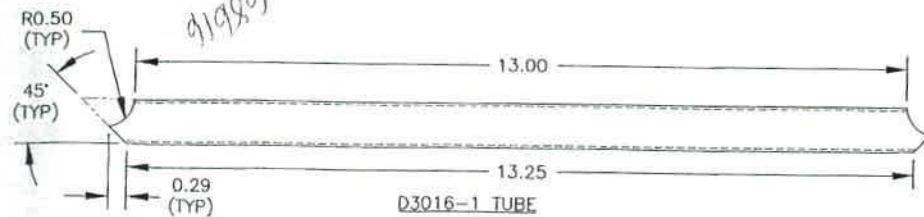
D3016-9 SADDLE



D3016-11 SADDLE



D3016-5 TUBE



D3016-1 TUBE

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		DATE 01.05.18	TITLE SEAT FRAME ASSEMBLY			SCALE 1:2

DEO ATTACHED
RELEASED
9.05.30

DRAWING NO. D3016	TITLE SEAT FRAME ASSEMBLY	REV. A	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3016-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>1</i>	CHECKED <i>47</i>	MFG. APPR. <i>EE</i>	APPROVED <i>WJ</i>	DE APPR. <i>#</i>		
DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29	DATE 10.01.29		

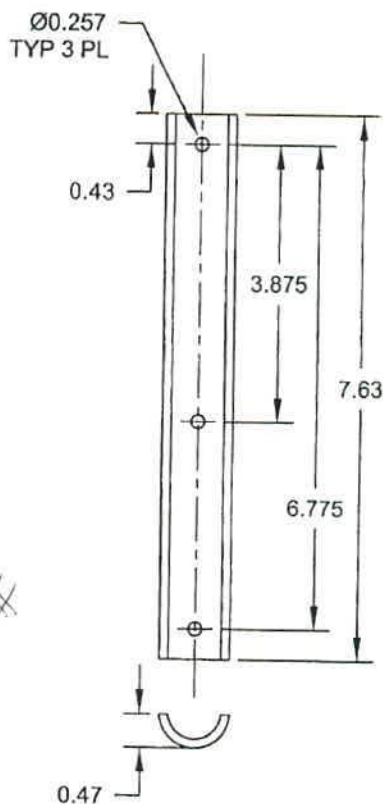
PURPOSE:

TO REVISE D3016-11 SADDLE'S HOLE SIZES

CHANGE:

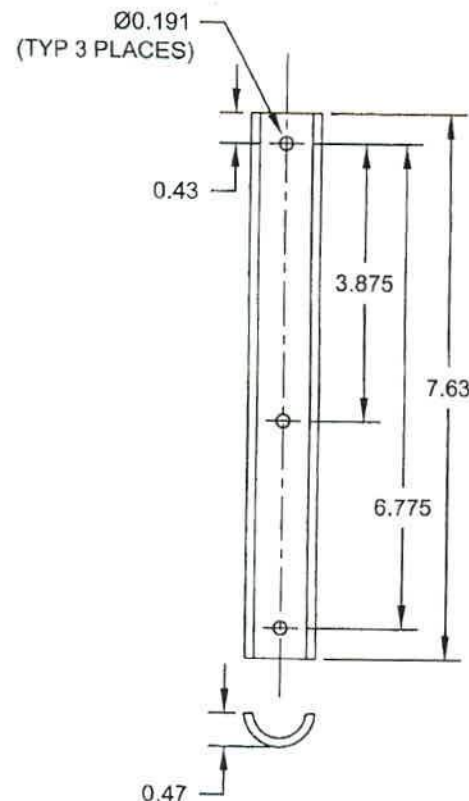
DETAIL D3016-11 SADDLE (SHEET 3): Ø0.257 TYP 3 PL WAS Ø0.191 (TYP 3 PLACES) AS SHOWN:

IS:



D3016-11 SADDLE

WAS:



D3016-11 SADDLE

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